

Work Order ID 84613

May-17-12 10:38:51 AM

84613

Page 1

Item ID: D3167-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 17/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/17 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3167	Rev A1					(4)			
120		0.00							
120	FLOW WATER JET								
Waterjet	Memo	0.00							B12-6-2
FLOW CNC Waterjet	Cut Blank as per File D3167-1_BLANK								
130		0.00							
130	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA285 and Dwg D3167 3-Deburr		PO/B.A	12/07/05		4	Ø		B12-6-2
140		0.00							
140	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control			PO/B.A	12/07/05		4	Ø		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84613

May-17-12 10:38:51 AM

84613

Page 2

Item ID: D3167-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 17/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location:

0.00

151

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

OK/2

12-07-09

(x4)

Perkins 14

K 12/7/10

ME 12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-17-12 10:38:55 AM

Page 1

Work Order ID: 84613

84613

Parent Item: D3167-1

D3167-1

Parent Item Name: Bearpaw

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	53.2100	3.6	14.4			

MUHMWB10

UHMW 1" Black

**

1812-6-2

Location	Loc Qty	Loc Code
MAT018	30.1	
120972	3	
121346	27.1	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

121851

121951

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

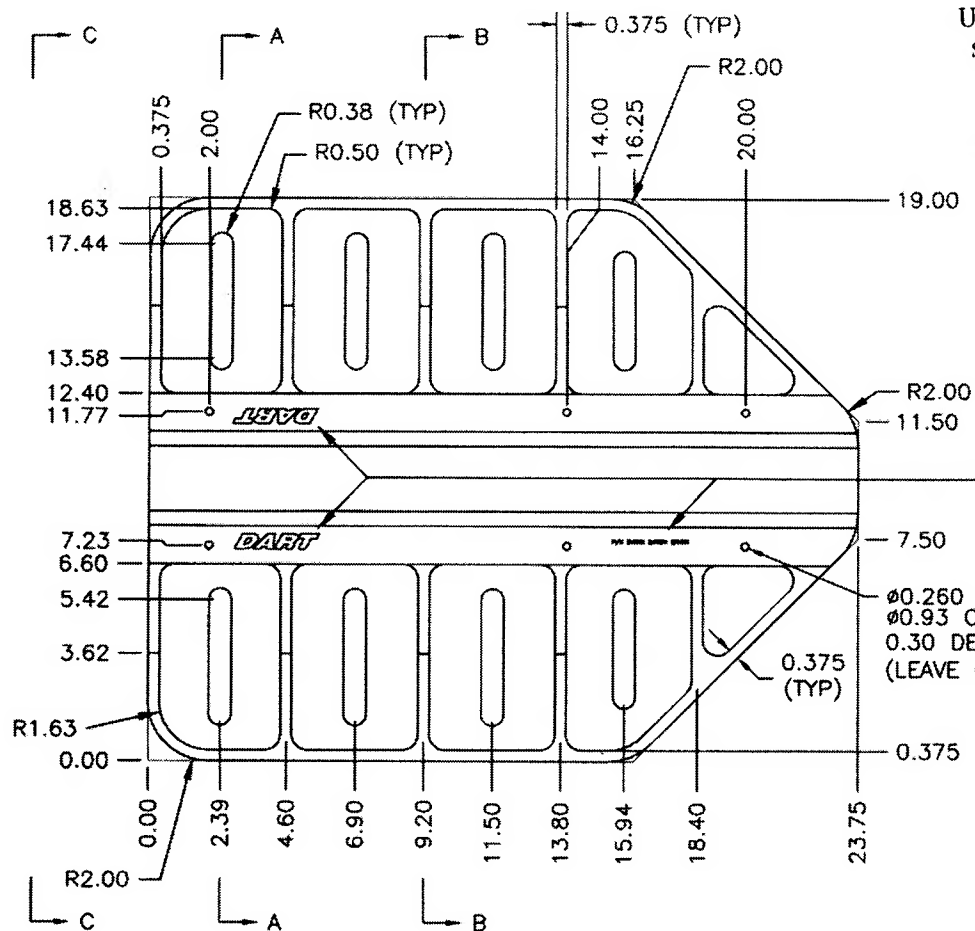
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QACOPY ISSUED

DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO.		REV. A	
DATE		D3167		SHEET 1 OF 2	
02.10.08		TITLE		SCALE	
		BEARPAW		1:6	
A	02.10.08	NEW ISSUE			
A1	02.12.17	5.80 WAS 5.50			

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

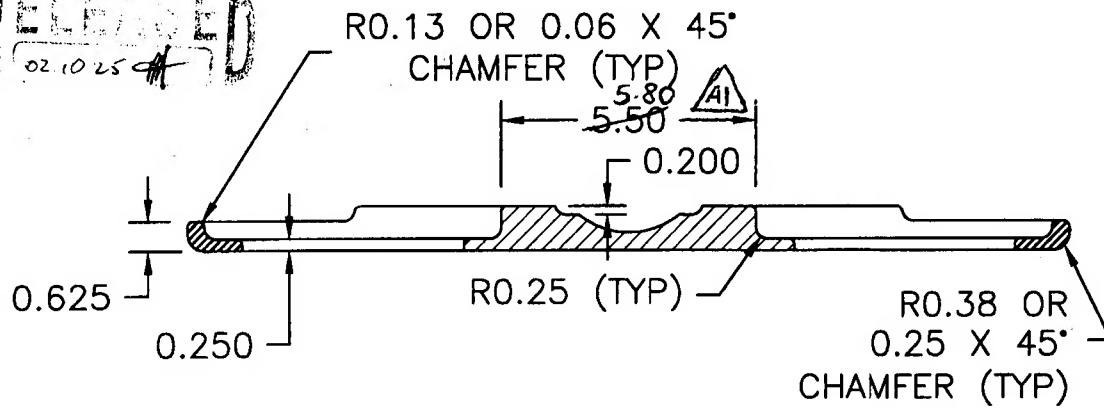
Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

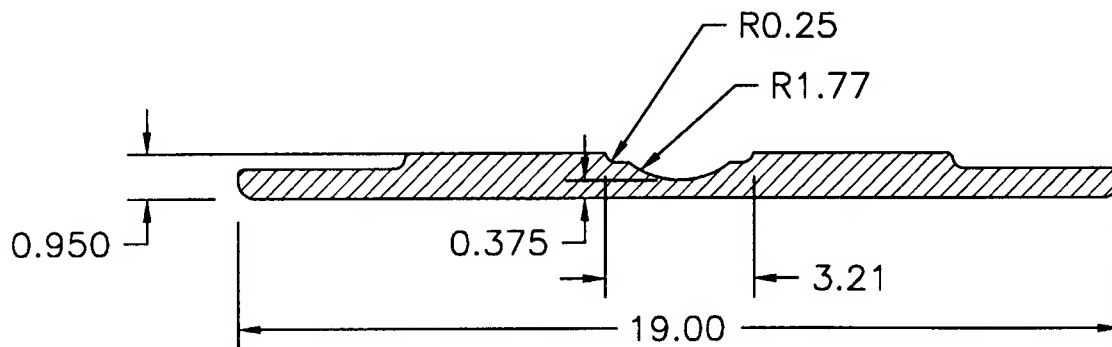


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

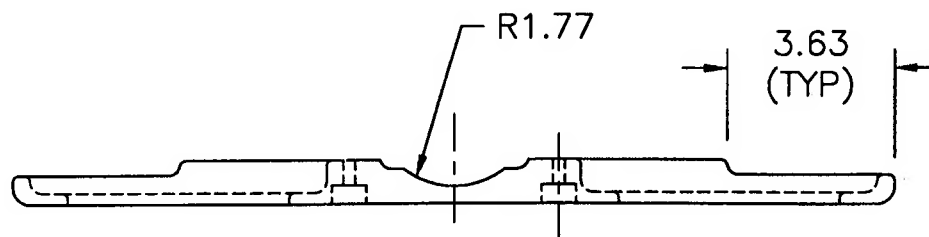
RELEASED
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

04613

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.063 x 45°	✓		PHD-01	VERN.
B	5.80	+/-0.030	5.799	✓		"	"
C	0.25 x 45°	+/-0.030	0.250 x 45°	✓		"	"
D	R0.25	+/-0.030	0.250	✓		Rad gauge	
E	0.200	+/-0.030	0.209	✓		PHD-09	
F	0.250	+/-0.010	0.243	✓		HB-120	
G	0.625	+/-0.030	0.624	✓		PHD-01	VERN.
H	0.375	+/-0.010	0.377	✓		HB-120	
I	0.950	+0.030/-0.010	0.949	✓		PHD-01	VERN.
J	3.21	+/-0.030	3.210	✓		"	"
K	19.00	+/-0.030	19.00	✓		PHD-11	M. TAPE
L	Ø0.260	+0.005/-0.000	0.260	✓		PIN gauge	
M	Ø0.93	+/-0.030	0.931	✓		PHD-01	VERN.
N	0.30	+0.030/-0.000	0.319	✓		PHD-09	
O	0.375	+/-0.030	0.379	✓		PHD-01	VERN.
P	7.23	+/-0.030	7.230	✓		H. gauge	
Q	4.54	+/-0.010	4.553450	✓		PHD-01	VERN.
R	2.00	+/-0.030	2.017	✓		PHD-01	"
S	12.000	+/-0.010	12.001	✓		H gauge	
T	6.000	+/-0.010	6.000	✓		PHD-01	VERN.
U	23.75	+/-0.030	23.750	✓		PHD-11	M. TAPE

Measured by: PD/B	Audited by: AT/ant	Prototype Approval:	N/A
Date: 12/07/05	Date: 12/07/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	